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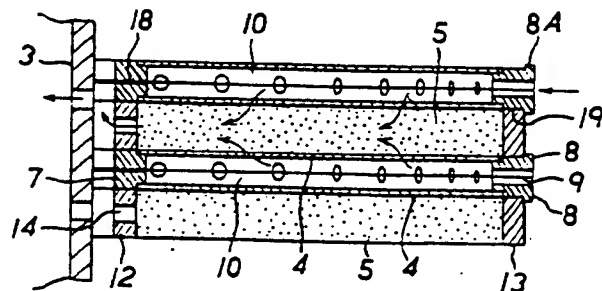
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54 POLYMER FILTERING APPARATUS.

57 A polymer filtering apparatus (1) is used to filter a molten polymer in a step of extruding a molten polymer to manufacture films and fibers. A plate type filter medium (4), which is incapable of resisting a filtration pressure, is supported at its rear portion on a liquid-permeable support member (5). Two pieces of filter media (4), (4) of the above-mentioned construction are arranged in opposition to each other so as to form a polymer passage (10) therebetween, and a polymer to be filtered is fed from this polymer passage (10) and through the filter medium (4) and support member (5). The plate type filter medium (4) and support member (5) which are detachably piled, can be separated, and the surfaces thereof can be easily washed. More-over, the results of washing of both the primary and secondary sides can be inspected visually with ease.



EP 0 220 324 A1

<TITLE OF THE INVENTION>
POLYMER FILTERING APPARATUS

<BACKGROUND OF THE INVENTION>

Field of the Invention

This invention relates to a polymer filtering apparatus particularly suitable for use in the production of films and fiber of polymers such as polyester, polyamide and the like.

Prior Art

When producing fiber or films by extruding a molten polymer through a nozzle or die, it is a matter of utmost importance to remove foreign matter from the polymer in order to obtain a product of satisfactory quality. For this purpose, there have been proposed and used various filters. For instance, there has been known in the art the so-called leaf filter which is constituted by a couple of filter members (hereinafter referred to as "fiber filters") stacked one on the other, each consisting of a thin disk-like metal fiber sinter with an opening at the center thereof, the filter members being secured to each other, for example, by welding outer peripheral portions thereof, a wire netting of a large mesh size interposed between the filter members to form a gap

space therebetween, and a porous plate for supporting the fiber filters. A filtering apparatus is formed by stacking a large number of such leaf filters one on another around the circumference of a support column (referred to as "polymer duct") which is centrally provided with a polymer passage. The polymer to be filtered is fed from outside of the leaf filters and passed through the fiber filters to enter the internal gap spaces and sent into the polymer duct through the center openings. During the filtering operation, each fiber filter which is insufficient in rigidity for withstanding the filtration pressure by itself is supported by the porous plate and wire netting.

The leaf filter of the above-described construction has a broad filtration area and employs fiber filters with narrow interstices, so that it is capable of removing foreign matter with high efficiency and widely used in the art. However, such a leaf filter has a number of problems to be solved. Namely, the fiber filter is very costly and therefore it is desired to be easily washable for repeated use. Nevertheless, a difficulty is encountered in washing the interior of the filter which is closed along its outer periphery. Besides, eye inspection of the filter which is usually required after washing to ascertain the effects of washing, especially inspection of the secondary side of the

filter which forms an exit for the polymer, is impossible because it is located on the inner side of the filter. Insufficient washing of the secondary side leaves the possibilities of the dust or other foreign matter on the secondary side mixing into the polymer during the filtering operation.

<SUMMARY OF THE INVENTION>

It is therefore an object of the present invention to eliminate the above-mentioned drawbacks or problems of the conventional counterparts, more particularly, to provide a polymer filtering apparatus which permits easy washing as well as eye inspection of both primary and secondary sides thereof.

In order to achieve these objects, the polymer filtering apparatus of the invention comprises a stack of paired flat plate-like filter members detachably fitted around the circumference of a polymer duct and a number of flat plate-like liquid-permeable support members detachably fitted around the circumference of the polymer duct on the upper and lower sides of the coupled filter members for supporting effective surfaces thereof, the filter members being located at a space from each other to form a polymer passage therebetween which polymer passage having a polymer inlet either at the inner or outer periphery thereof, and said support members having a polymer outlet on the side away from the

polymer inlet.

With the polymer filtering apparatus having the above-described construction according to the invention, each couple of the filter members which are supported by overlying or underlying liquid permeable support members are located in face-to-face relation, forming therebetween a polymer passage into which a polymer to be filtered is fed through the support members. The flat plate-like filter members and support members are detachably stacked, so that they can be easily disassembled for cleaning their surfaces or for other purposes, and the results of washing on the primary and secondary sides can be easily inspected with naked eyes.

The above and other objects, features and advantages of the invention will become more apparent from the following description and the appended claims, taken in conjunction with the accompanying drawings which show by way of example preferred embodiments of the invention.

<BRIEF DESCRIPTION OF THE DRAWINGS>

In the accompanying drawings:

Fig. 1 is a schematic sectional view of a polymer filtering apparatus according to the invention;

Fig. 2 is a fragmentary sectional view on an enlarged scale of filter members and support members employed in the embodiment of Fig. 1;

Fig. 3 is a fragmentary perspective view of the filter member;

Fig. 4 is a fragmentary perspective view of the support member;

Fig. 5 is a view similar to Fig. 2 but showing another embodiment of the invention; and

Fig. 6 is a sectional view showing the respective components of Fig. 5 in disassembled state.

<DESCRIPTION OF PREFERRED EMBODIMENTS>

Now, the invention is described more particularly by way of preferred embodiments shown in the drawings.

Referring to Fig. 1, there is shown in section an embodiment of the invention, in which the polymer filtering apparatus indicated generally by the reference numeral 1 has a cylindrical casing 2, a vertically extending polymer duct 3 located substantially at the center of the casing 2, and a large number of disk-like filter members 3 and support members 5 stacked around the circumference of the polymer duct 3. As illustrated on an enlarged scale in Fig. 2, couples of the filter members 4 are stacked alternately with a support member 5.

As shown in Fig. 3, the filter member 4 has an inner hub ring 7 and an outer hub ring 8 securely fixed to the inner and outer peripheries thereof by welding or other

suitable means. The outer hub ring 8 is formed with a large number of radial grooves 9 at suitable intervals. As shown particularly in Fig. 2, a couple of filter members are overlapped with the respective inner and outer hub rings 7 and 8 in contact with each other, so that the filter members 4 are spaced from each other by a suitable distance to form a polymer passage 10 therebetween. The inner periphery of the polymer passage 10 is closed by the inner hub rings 7, while its outer periphery is provided with polymer inlets which are formed by the grooves 9 in the outer hub rings 8. Although the inner and outer hub rings 7 and 8 are fixed to the filter member 4 in the particular embodiment, they may be provided as separate parts and inserted between the filter members 4 when assembling same. In such a case, there is no need for providing the inner and outer hub rings 7 and 8 for each one of the overlapped filter members as shown in Fig. 2, namely, it suffices to insert one inner hub ring and one outer hub ring which is provided with radial holes as the polymer inlets instead of the above-described radial grooves 9.

As the filter members 4, there may be employed the fiber filter which have been conventionally used for the leaf filters, that is to say, the fiber filters which are obtained by sintering non-woven fabric of fine and long metal fiber. The fiber diameter, openness of interstices and thickness of

the fiber filter are determined suitably according to the required polymer filtering accuracy. Normally, the fiber filter has an openness of 3 - 40 microns and a thickness of 0.2 - 2 mm. In place of the fiber filter, there may be employed a sinter of metal granules, short metal fiber or the like. The filter member 4 to be used in the present invention formed in a relatively small thickness in consideration of the polymer filtration pressure and washability, and therefore singly do not has a rigidity for enduring the filtration pressure.

The disk-like support member 5 has a rigidity sufficient for enduring the filtration pressure to support the effective surfaces of the overlying and underlying filter members 4 against the filtration pressure, along with liquid permeability to pass the polymer in radial directions. A support member with such properties is obtained by forming same integrally from a sintered metal plate with an extremely high porosity. However, the support member 5 is not restricted to such a sintered metal plate of an integral structure because various alterations are possible. For example, it may be constituted by a combination of a couple of porous plates and a wire netting of a large mesh size which serves to maintain a suitable gap space between the two porous plates as seen in the conventional leaf filters, or by a

liquid permeable sintered metal plate instead of the just-mentioned porous plates. Alternatively, it may be formed by overlapping a couple of sintered metal plates which are provided with a large number of radial grooves on the respective meeting sides to permit polymer flows therethrough.

As illustrated in Figs. 2 and 4, the support member 5 has inner and outer hub rings 12 and 13 securely fixed to its inner and outer peripheries, respectively. The inner hub ring 12 is formed with polymer discharge ports 14. The sintered metal plate which constitutes the support member 5 is greater than the filter member 4 in the degree of openness to minimize the resistance of passage of the polymer and to prevent blocking by solid foreign matter which may be contained in the polymer. Materials of various shapes such as granules, short fiber, long fiber and the like can be used for forming the sintered support plate, but it is preferred to employ a spherical or ball-like material with smooth surfaces, for example, steel balls with low resistance to polymer passage. Although it is desirable to employ steel balls of a large size from the standpoint of reducing the resistance to polymer passage, but steel balls of a smaller size are desirable from the standpoint of supporting the filter members stably. In consideration of these contrary factors, it is preferred to employ a size in the range of 1.0

- 0.1 mm. Long metal fiber with smooth surfaces is also preferred. Sinter which has long metal fiber filaments arranged three-dimensionally in random directions is also suitable for the support member 5 since it has an extremely large porosity, with low resistance to polymer passage especially in a lateral direction (in a direction parallel with the upper and lower sides) and insusceptibility of defoliation of metal fiber under the filtration pressure. The diameter of the long metal fiber to be used for the support member is preferred to be in the range of about 1.0 - 0.1 mm, more preferably in the range of 0.3 - 0.6 mm. The sintered metal plate may consist of a plate as obtained by sintering metal particles, short or long metal fiber with or without grinding the filter-contacting surfaces for flattening the exposed grains to support the filter stably without deformations.

Although the sintered metal plate which constitutes the support member 5 is arranged to support the filter member 4 in direct contact therewith in the particular embodiment shown, a secondary filter may be interposed between them if desired. In such a case, it is desirable to employ a secondary filter which has a function of catching and rupturing gel in addition to a function of mixing the polymer, for example, a sinter of deformed metal particles with a multitude of

sharp edges or a sinter of deformed short metal fiber with a multitude of sharp edges. Sinters of deformed particles or short fiber are particularly suitable in view of the high porosity, low resistance to polymer passage and functions of catching and rupturing the gel in the polymer. The degree of openness of the secondary filter is preferred to be greater than that of the filter member 4 to prevent blocking by solid foreign matter which has passed through the filter member 4 and to facilitate its washing and reuse. The secondary filter may be fixedly or detachably bonded to the opposite sides of the support member 5. It is also possible to form the support member 5 from a sinter of the above-mentioned deformed metal particles or short fiber to impart thereto the functions of the secondary filter.

As shown in Fig. 1, a holder plate 16 and a nut 17 is mounted on top of the filter and support members 4 and 5 which are stacked around the circumference of the polymer duct 3. The holder plate 16 presses down and seals the inner hub rings 7 and 12 as well as the outer hub rings 8 and 13. If necessary, suitable seal material 18 and 19 is interposed between the inner and outer hub rings. In Fig. 2, the outer hub rings 8 of the filter members 4 are each provided with an annular projection 8A around the respective circumference, which projection 8A is fittingly engageable with the outer

hub ring of the adjacent support member, facilitating to assemble the seal material 19 and support members 5 in predetermined positions. These projections may be provided on the part of the outer hub rings of the support members if desired.

The polymer filtering apparatus with the above-described construction operates in the manner as follows.

A polymer which is fed into the casing 2 from above in Fig. 1 flows into the polymer passages 10 between the coupled filter members 4 through the polymer inlets 9 in the outer hub rings 8 as shown in Fig. 2. The polymer which has been passed through the filter members 4 is permitted to flow through the support members 5 in radially inward directions and collected in the polymer duct 3 through the polymer exits 14 in the inner hub rings 12 and then discharged from the apparatus. In this filtering operation, the filter members 4 are suitably protected against the filtration pressure by the overlying or underlying support members although the filter members per se are not capable of enduring the filtration pressure.

For washing the filter and support members 4 and 5, they are removed from the polymer duct 3 and washed respectively. Since the filter member 4 is simply in the form of a disk as shown in Fig. 3, it is quite easy to wash and

visually inspect the opposite filter surfaces. The support member 5 can be washed and visually inspected in a similar manner.

In the foregoing embodiment, the polymer is fed into the polymer passage between each couple of filter members 4 through the outer hub rings and discharged into the polymer duct 3 through the inner hub rings. However, it is possible to filter the polymer in the opposite direction, namely, by providing inlet grooves in the inner hub rings 7 of the filter members 4 and closing the polymer passages 10 with outer hub rings 8 at the respective outer peripheries, while providing polymer outlets in the outer hub rings 13 of the support members 5 which are closed with the inner hub rings 12 at the respective inner peripheries. With this arrangement, the polymer which is fed from the polymer duct 3 into the polymer passages 10 between the coupled filter members 4 flows into the support members 5 through the filter members 4 and then in radially outward directions through the support members 5. The polymer which is discharged into the casing 2 is sent out through its top.

Referring to Fig. 5, there is shown another embodiment of the invention in a sectional view similar to Fig. 2. Fig. 6 shows the components of the filtering apparatus of Fig. 5 in disassembled state. In this embodiment, each disk-

like filter member 4 has inner hub rings 20A and 20B and outer hub rings 21A and 21B securely fixed on the upper and lower sides of its inner and outer peripheries, respectively, by welding, brazing or other suitable means. An annular spacer 22, for example, a wire netting of a large mesh size is interposed between the outer hub rings 21B between the filter members 4. Positioned on the outer sides of the coupled filter members 4 are secondary filter members 24 of sintered metal and support members 25. The support member 25 is formed by producing sintered metal plates 27 integrally on the opposite sides of a wire netting 26 which is extended to a position where it is gripped between the inner hub rings 20A. The sintered metal plate 27 is preferred to be a sinter with high porosity and low resistance to polymer passage, desirably a sinter containing long metal fiber filaments extending three-dimensionally in random directions, especially in zig-zag forms in vertical directions. The reference numeral 30 denotes a seal material.

The above-described component parts are stacked in the manner as shown in Fig. 5, defining between a pair of filter members 4 a polymer passage 31 having a polymer inlet formed at its outer periphery by the spacer 22 and closed at its inner periphery. On the other hand, polymer outlets are foemed by wire nettings at the inner peripheries of the

secondary filters 24 and support members 25 which are closed at the outer peripheries. As indicated by arrows in Fig. 6, the polymer which is fed to the polymer passage between the filter members 4 is likewise filtered by passing same through the filter members 4 and then through the secondary filters 24 to flow into the support members 25. The filter members 4, secondary filters 24 and support members 25 can be washed wholly as they can be disassembled easily. In case a polymer is fed from the polymer duct 3, a polymer inlet is formed by interposing the spacer 22 between the opposing inner hub rings 20B while closing the outer hub rings 21B. On the other hand, the inner periphery of the support member 25 is closed with the inner hub rings 20A, and a polymer outlet is formed at its outer periphery by the wire meshing 26.

Although filter and support members of circular shapes are employed in the foregoing embodiments, they are not restricted to circular shapes and may be formed in rectangular or other arbitrary shapes.

As described hereinbefore, the filter and support members of the invention are detachable from the polymer duct, and the filter members are in the form of a simple flat plate, so that they permit easy washing and inspection of both sides, in contrast to the conventional filters which are closed at the inner and outer peripheries. Accordingly,

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it is possible to confirm the condition of washed parts before reuse for precluding the problems which would be caused by defective washing. Consequently, it becomes possible to increase the number of times of recycling of the filter and support members and to cut the running cost of the filtering apparatus to a significant degree.

WHAT IS CLAIMED IS:

1. A polymer filtering apparatus, comprising:

a stack of coupled filter members of flat plate-like shape stacked one on the other and detachably fitted on the circumference of a polymer duct and incapable of enduring filtration pressure by themselves, said filter members being spaced from each other to form a polymer passage therebetween; and

a number of liquid permeable support members of flat plate-like shape detachably fitted on the circumference of said polymer duct one on each side of said coupled filter members to support effective surfaces thereof;

said polymer passage being provided with a polymer inlet on a side at the inner or outer periphery of said filter members and closed on the other side; and

said support members being closed on the side of said polymer inlet and provided with a polymer outlet on the other side.

2. The polymer filtering apparatus of claim 1, wherein said filter members each has an inner hub ring and an outer hub ring with a large number of radial grooves securely fixed to the inner and outer peripheries thereof and stacked one on the other with the respective outer hub rings in

6 abutting engagement with each other, the polymer passage
7 between said filter members being closed with said inner hub
8 rings at the inner periphery and having polymer inlets formed
9 at the outer priphery by said radial grooves of said outer
10 hub rings.

1 3. The polymer filtering apparatus of claim 1, where-
2 in said filter members each has an inner hub ring with a
3 large number of radial grooves and an outer hub ring securely
4 fixed to the inner and outer peripheries thereof on a side
5 facing the other filter member and stacked one on the other
6 with the respective hub rings in abutting engagement with
7 each other, the polymer passage between said filter members
8 being closed with said outer hub rings at the outer periphery
9 and having polymer inlets formed at the inner periphery by
9 said radial grooves of said inner hub rings.

1 4. The polymer filtering apparatus of claim 1, where-
2 in an inner hub ring and an outer hub rings are inserted
3 between said couple of filter members to form a polymer
4 passage therebetween, which polymer passage being closed with
5 said inner hub ring at the inner periphery thereof and
6 having polymer inlet holes formed through said outer hub
7 rings.

1 5. The polymer filtering apparatus of claim 1, where-
2 in an inner hub ring and an outer hub ring are inserted

between said couple of filter members to form a polymer passage therebetween, which polymer passage being closed with said outer hub ring at the outer periphery thereof and having polymer inlet holes formed through said inner hub rings.

6. The polymer filtering apparatus of claims 1 to 5, wherein said filter member constituted by a fiber filter formed by sintering non-woven cloth of fine long metal fiber filaments with interstices of 3 - 40 microns and a thickness of 0.2 - 2 mm.

7. The polymer filtering apparatus of claims 1 to 5, wherein said filter member constituted by a sinter of metal granules or short metal fiber.

8. The polymer filtering apparatus of claims 1 to 5, wherein said flat plate-like support member is constituted by a sintered metal plate of a unitary structure with a high porosity.

9. The polymer filtering apparatus of claims 1 to 5, wherein said flat plate-like support member is constituted by a combination of a couple of porous or liquid-permeable sintered metal plates and a wire netting of a large mesh size spacing said sintered metal plates at a suitable distance from each other.

10. The polymer filtering apparatus of claims 1 to 5, wherein said flat plate-like support member is constituted by

3 a couple of sintered metal plates each having a large number
4 of radial grooves on the meeting side to form polymer
5 passages therebetween.

1 11. The polymer filtering apparatus of claims 8 to
2 10, wherein said sintered metal plate of said support member
3 is formed by sintering 1.0 - 0.1 mm diameter steel balls with
4 smooth surfaces.

1 12. The polymer filtering apparatus of claims 8 to
2 10, wherein said sintered metal plate of said support member
3 is formed by sintering 1.0 - 0.1 mm diameter long metal fiber
4 with smooth surfaces, arranged three-dimensionally in random
5 directions.

1 13. The polymer filtering apparatus of claims 8 to
2 10, wherein said sintered metal plate is ground to flatten
3 metal grains exposed on a surface to be contacted with a
4 filter member.

1 14. The polymer filtering apparatus of claim 1,
2 wherein said support member has an inner hub ring and an
3 outer hub ring securely fixed to the inner and outer
4 peripheries thereof, one of said inner and outer hub rings
5 being provided with a polymer outlet.

1 15. The polymer filtering apparatus of claim 1,
2 further comprising between said support member and filter
3 member a secondary filter member having functions of mixing

said polymer and catching and rupturing gel in said polymer.

16. The polymer filtering apparatus of claim 1, wherein said support member itself is arranged to act also as a secondary filter with functions of mixing said polymer and catching and rupturing gel in said polymer.

17. The polymer filtering apparatus of claims 15 and 16, wherein said secondary filter is formed by a sinter of deformed metal grains or short metal fiber with a multitude of sharp edges.

18. The polymer filtering apparatus of claim 1, wherein a liquid-permeable spacer is inserted in said polymer passage between said filter members and gripped between said inner hub rings or outer hub rings to form a polymer inlet thereat.

FIG. 1

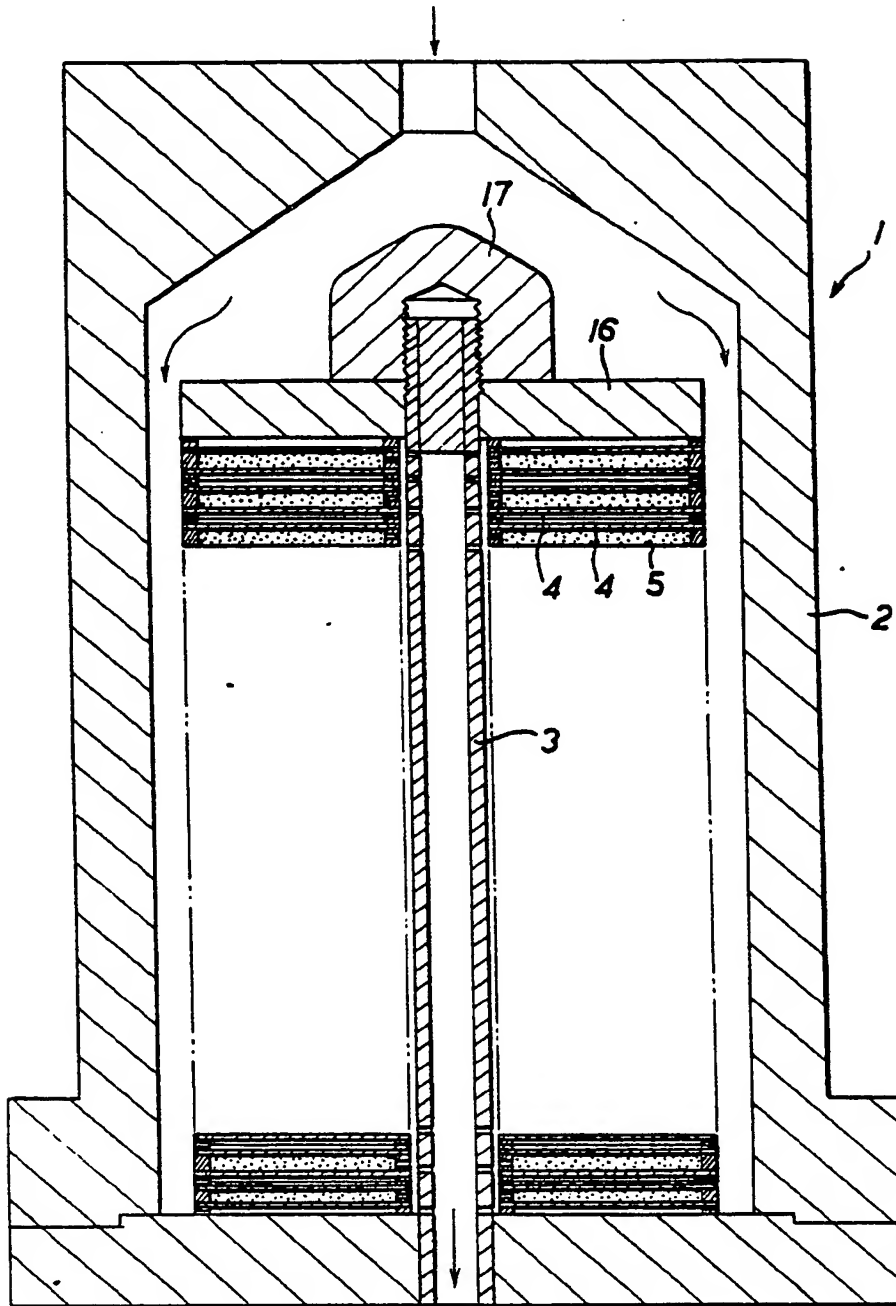


FIG. 2

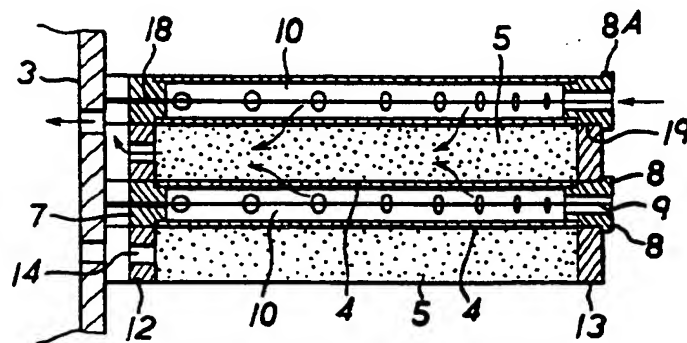


FIG. 3

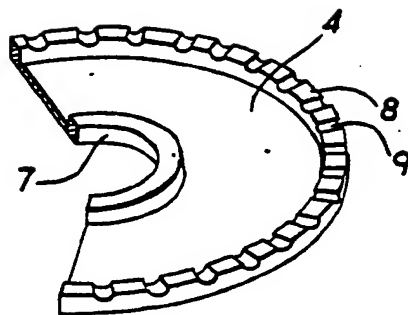


FIG. 4

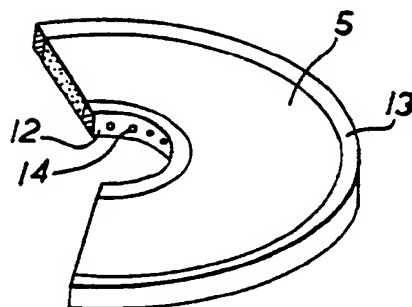


FIG. 5

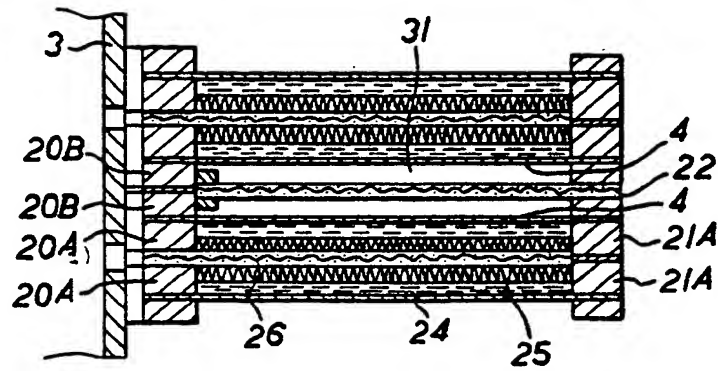
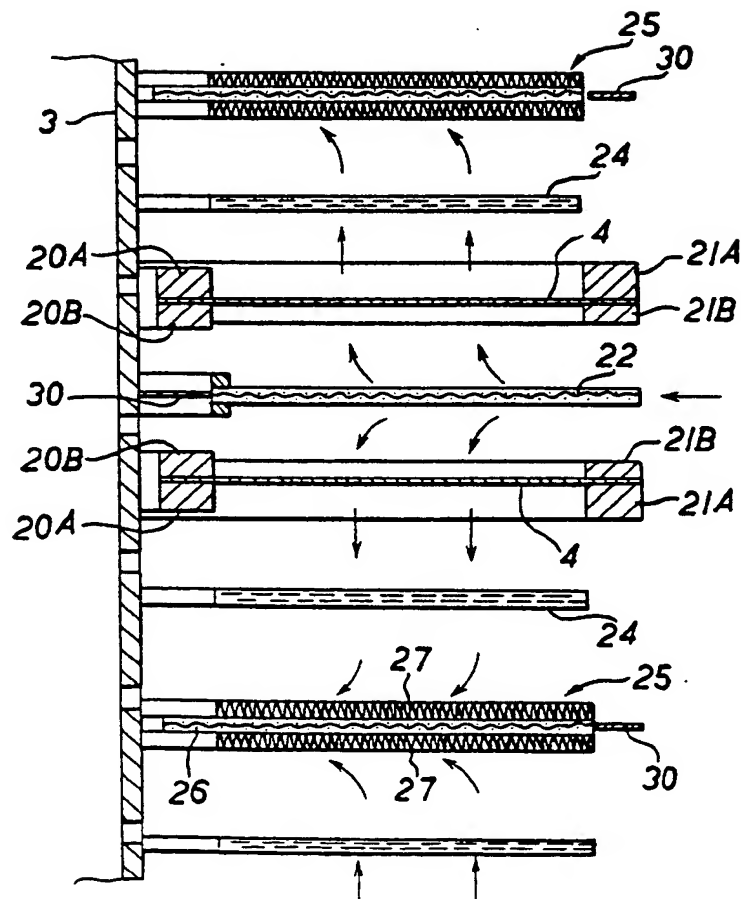


FIG. 6



INTERNATIONAL SEARCH REPORT

0220324

International Application No.

PCT/JP86/00205

I. CLASSIFICATION OF SUBJECT MATTER (if several classification symbols apply, indicate all) ²		
According to International Patent Classification (IPC) or to both National Classification and IPC		
Int.Cl ⁴ B29B13/10, B01D29/34		
II. FIELDS SEARCHED		
Minimum Documentation Searched ⁴		
Classification System	Classification Symbols	
IPC	B29B13/10, B01D29/34, 35/02	
Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched ⁴		
Jitsuyo Shinan Koho		1926 - 1986
Kokai Jitsuyo Shinan Koho		1971 - 1986
III. DOCUMENTS CONSIDERED TO BE RELEVANT ¹¹		
Category ¹²	Citation of Document, ¹² with indication, where appropriate, of the relevant passages ¹⁷	Relevant to Claim No. ¹⁸
Y	JP, U, 54-32885 (Nippon Standard Associate Kabushiki Kaisha, Sumitomo Electric Industries, Ltd.) 3 March 1979 (03. 03. 79) (Family: none)	1, 4, 5, 8, 12, 14, 16
Y	JP, U, 50-153589 (Teijin Limited) 19 December 1975 (19. 12. 75) P.1, line 12 to p.2, line 3, Fig. 1 (Family: none)	7
<p>¹² Special categories of cited documents: ¹¹</p> <p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier document but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p> <p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art</p> <p>"&" document member of the same patent family</p>		
IV. CERTIFICATION		
Date of the Actual Completion of the International Search ¹	Date of Mailing of this International Search Report ²	
July 2, 1986 (02. 07. 86)	July 14, 1986 (14. 07. 86)	
International Searching Authority ¹	Signature of Authorized Officer ²⁰	
Japanese Patent Office		

